

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC p6: 3,8mm

Order data

| | |
|--------------|---------------|
| Order number | 122736 3,8 |
| GTIN | 4045197567031 |
| Item class | 11E |

Description
Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. With **140° point angle** and special **j6 cutting edge tolerance** for optimum generation of a pilot hole.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

For deep-hole drilling deeper than 12×D a pilot hole is recommended, and for deep-hole drilling from 20×D to 30×D it is essential.

The generation of a pilot hole improves process reliability.

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122738**.

Form **HE**: order with **No. 122736 + 129100HE**.

Technical description

| | |
|--------------------------------------------|--------------|
| Flute length L_c | 36 mm |
| Nominal Ø D_c | 3.8 mm |
| Feed f in steel < 1100 N/mm ² | 0.08 mm/rev. |
| Number of cutting edges Z | 2 |
| Shank tolerance | h6 |
| Tolerance nominal Ø | p6 |
| Shank Ø D_s | 6 mm |

| | |
|---------------------------------------------------|-------------------|
| Overall length L | 74 mm |
| Standard | DIN 6537 |
| recommended maximum drilling depth L ₂ | 30.3 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 6×D |
| Point angle | 140 degrees |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | yes, with 25 bar |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Colour ring | green |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|-------------|----------------|----------|
| Steel < 500 N/mm ² | suitable | 170 m/min | P |
| Steel < 750 N/mm ² | suitable | 130 m/min | P |
| Steel < 900 N/mm ² | suitable | 120 m/min | P |
| Steel < 1100 N/mm ² | suitable | 110 m/min | P |
| Steel < 1400 N/mm ² | suitable | 65 m/min | P |
| INOX < 900 N/mm ² | suitable | 75 m/min | M |
| INOX > 900 N/mm ² | suitable | 70 m/min | M |
| GG(G) | suitable | 95 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| Air | suitable | | |

Services

Shank grinding Type HE

129100 HE